

Thursday, August 22, 2013 9:06:39 AM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

16

16

Customer:

Reference:

Date: 13-8-22

Tooling:

Date:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

Operation Description

Set Up/ Run Hours

[illegible]

Revision Nbr

D4007

A

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 21026
Purchase part as per Dwg D4007
Possible Supplier: GFI
Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

DAS
27
9-89

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Work Order ID 105850

Thursday, August 22, 2013 9:06:39 AM

105850

Page 2

Item ID: D4007-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: SUPPORT

Stop ***NS2***

Start Date: 8/22/2013 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/29/2013 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

16 13-9-18

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

16

13-09-18

150

Identify as per dwg & Stock Location: ST

0.00

150

Packaging

Memo

0.00

Packaging

242

16 13/9/18

DAS
32
200

Work Order ID 105850***105850***

Page 3

Thursday, August 22, 2013 9:06:39 AM

Item ID: D4007-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SUPPORT

Start Date: 8/22/2013 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/29/2013 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 13-09-19

MF
13-9-18

Picklist Print

Thursday, August 22, 2013 9:06:38 AM

Page 1

Work Order ID: 105850

Parent Item: D4007-3

Parent Item Name: SUPPORT

Start Date: 8/22/2013

Required Date: 8/29/2013

Start Qty: 16.00

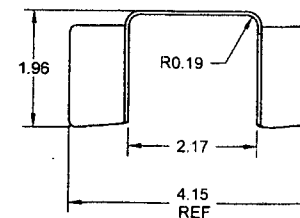
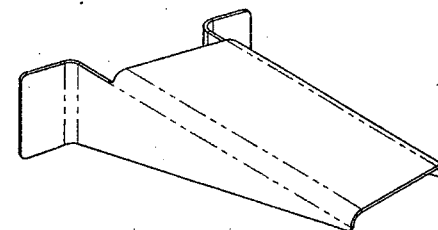
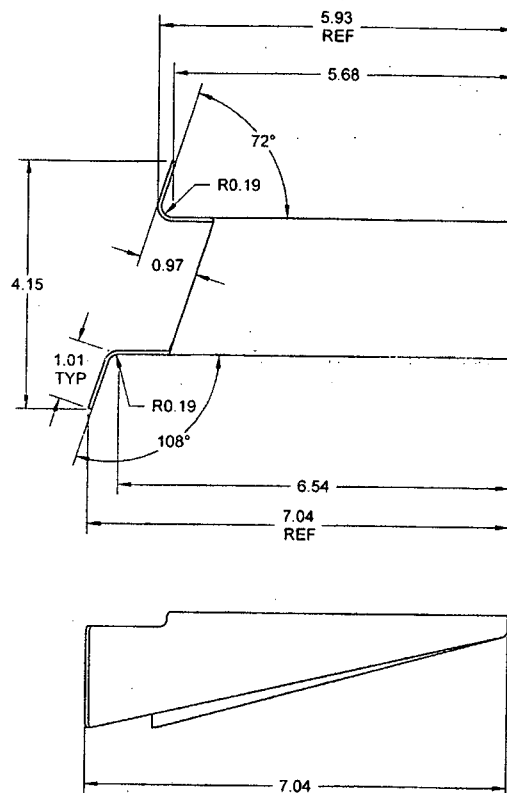
Required Qty: 16.00

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD
562 DD verified by:EC

IPP Rev:B 10.05.03 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4007-3P Support		Purchased	No			110	Each	0.0000	1	16		8/23/13	(16)

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-1	JCA-M47-2-02



D4007-1 TOP SUPPORT BRACKET

NOTES:

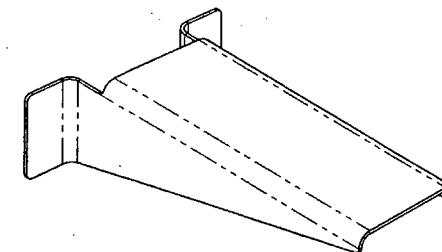
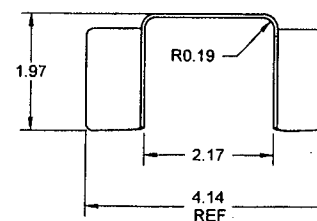
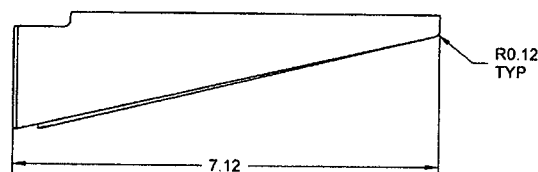
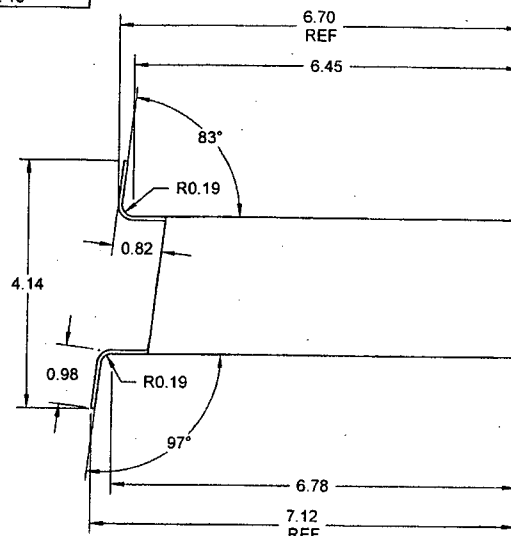
- 1) MATERIAL: MADE FROM D4007-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.17 lbs

RELEASED
2010-05-05

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4007	SHEET 1 OF 5
TITLE SUPPORT	SCALE NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



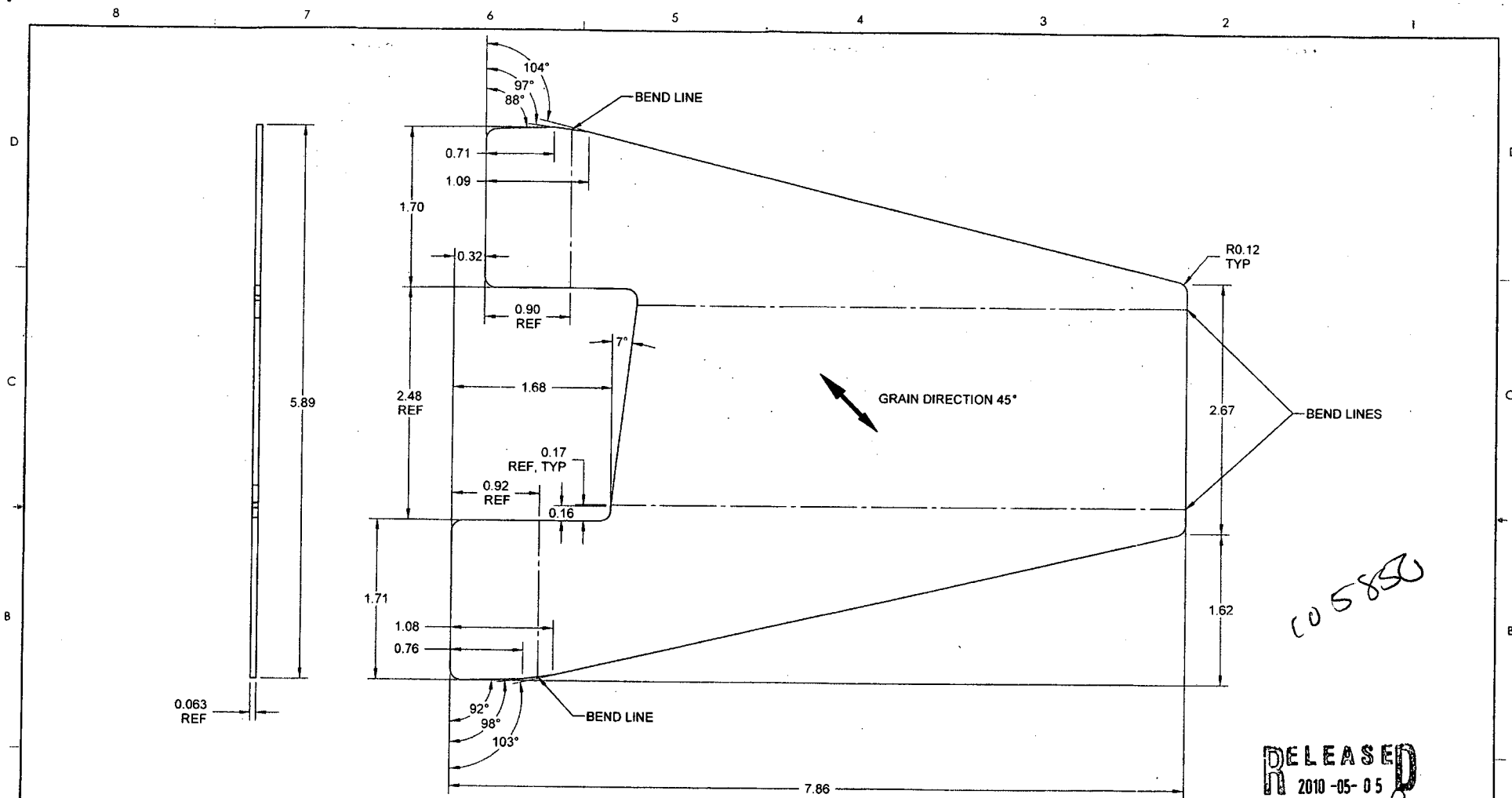
D4007-3 TOP SUPPORT BRACKET

105850

RELEASED
2010-05-05
MP

- NOTES:**
- 1) MATERIAL: MADE FROM D4007-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4007	REV. A
MFG. APPR.		TITLE SUPPORT	SHEET 3 OF 5
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.02.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



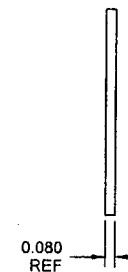
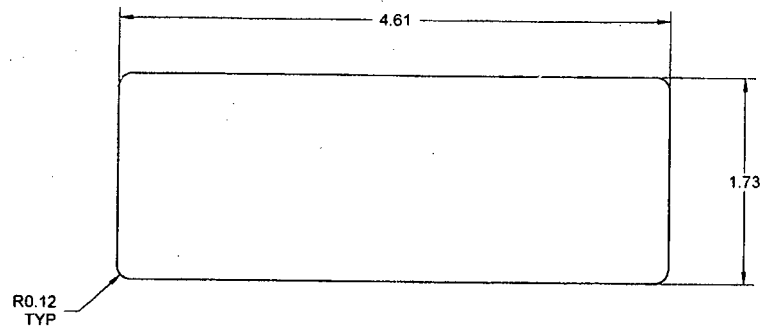
D4007-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-5	JCA-M47-2-24



D4007-5 PACKER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
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RELEASED
2010-05-05
MP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO21026**

Purchase Order Date 8/22/2013

PO Print Date 8/23/2013

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

*REVISED
date*

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4007-3P AS PER DWG D4007 REV. A B105850	Support	9/18/2013 Yes 9/18/2013		16.00 Each	\$110.00	\$1,760.00

Line Total: \$1,760.00

PO Total: \$1,760.00

CL

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

PST# 6122-5207

Change Nbr: 2

Change Date: 8/23/2013



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE				N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR	DY	MO	AN	YR		
13	09	13			0520941	1/1



VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299		0273220	PO21026	
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.		DESCRIPTION	

16 D4007-3P

SUPPORT

ITEM 1
C OF C REQ'D

MFG. JOB# J0273220 - 001 QTY 16 pcs

DUE DATE: 18 September 2013



EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.

REÇU PAR / RECEIVED BY

DATE



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	7	OUR JOB NO	J0273220	SHIPPING MEMO	0520941	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	16 PCS	PO21026	D4007-3P		SUPPORT	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
063 THK AL 2024 T3 (AMS-QQ-A-250/4)		TW METALS / ALCOA INC		776745		
PROCESS			PROCESSOR		RELEASE NOTE #	
1	FIRST ARTICLE INSPECTION REPORT ON FILE			GFI		N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0273220-001 (16 PCS)					
3	MATERIAL CERTIFICATION ATTACHED					
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 13 SEPTEMBER 2013

G.F.I. Q.C. REP.

2
CONTROLE
QUALITE



O'Neal High-Performance Metals Group

175 TUBEWAY
FOREST PARK GA 30297
Tel: 404-361-5050
FAX: 4043617052

CERTIFICATE OF COMPLIANCE

Your Order Number: 0082699

Our delivery receipt Number: 70513335

Date: 7/17/13

This is to certify that the material shipped against the above order on the above delivery receipt, consisting of:

Quantity: 87.092 LB

Line Number: 1

Grade: 2024T3 ALUM BARE SHEET .0630

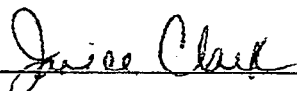
Part #: AS0634814424

Heat Number: 776745

Specification:

Complies in all respects with the item description.

BY:


Authorized Test Department Clerk

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Rob d. Woodall
Rob Woodall
Director of Manufacturing Davenport Works

Terrence Thom
Terrence Thom
Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

1503664	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2013-03-29	7860705	00000	1000461389-1 DP-61389-1
P.O. No./Govt Contract No.	Customer	Alcoa Item	
M49289616 Ln#: 001	TW METALS-FOREST G041015405R11		

Page 1 of 2

Ship To: TW METALS INC
175 TUBEWAY
FOREST PARK 30298 GA

Item Description
0.063 IN TK (+.0030 -.0030) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) CAT X 05313 (N) A/T 2024-
T3 FLAT SHEET MILL FINISH. AMS-QQ-A-250/4
REV A IS 2010 EXC_MRK AMS4037 REV P EXC_MRK
ASTMB209 REV 10 ((MARKED)) KRAFT PAPER
INTERLEAVED. MAX
GROSS SKID WGT: 4750 LB QUAN TOL +/-10 %
CQR D126153 REV 38 CUST REQ 13-03-
23 *** W/E 13-03-30 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	498423	776745	3938	91	PC	27279 47343

Notes for CQR: D126153.38
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDM ENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS -QQ-A-250/4.
CQR: D126153.38 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T3	Long Transv.	Max		
		Min	63.0	42.0 15

Chemical Composition

Alloy	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 2024	Max	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.15
	Min			3.8	0.30	1.2					

REMAIN

TEST REPORTS
ACCEPTED BY

APR 01 2013
[Signature]
TW METALS

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terence Thom
Terence Thom
Quality Assurance Manager

1503664	0		
Ship Date	B.I. No.	Invoice No.	Alcoa No. Item
2013-03-29	7860705	00000	1000461389-1 DP-61389-1
P.O. No./Govt Contract No.	Customer	Alcoa Item	
M49289616 Ln#: 001	TW METALS-FOREST G041015405R11		

Page 2 of 2

CQR: D126153.38 -Specification Limits (cont.)

Lot: 776745 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No-> Test	UTS KSI	TYS KSI	EL4D PCT
T3	Long Transv.	6	65.8	45.2	19.7
			65.7	45.1	19.1
			65.8	45.1	19.1
			65.7	45.2	19.3
			66.2	45.3	19.4
			65.6	45.1	17.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9704061	Actuals	0.06	0.17	4.7	0.65	1.5	0.00	0.07	0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

